

Order ID 112621

112621

Page 1

ary-03-14 7:42:17 AM

Item ID: D206-642-641

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

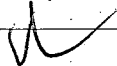
Start Date: 2/03/14 Start Qty: 1.00 **

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 1.00 **

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3288	Rev H
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0.00

100

100

DC

0.00

Document Control

Memo

Photocopy bluefile and create labels per PPP D206-642-641
CHG004



Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 2

Item ID: D206-642-641

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/11/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr FWD edge of tube, grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288, Grind to obtain proper fit

A/R AL ROD Batch: M122324/M127069

4-Grind welds flush to cap on top surface only.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9- open float holes section J-J (6 per side) to 0.297" and aft cap holes to 0.208"

10-Insert D3286-1 doubler using DT8732 & DT8879, then locating doubler off the 3/16" holes cleco D3286-1 doubler remove DT8879

11-Working from center out, drill #30 holes into D3286-1 Doubler, cleco each hole after its drilled, Verify angle of holes to accomodate rivet heads.

12-Install DT8879 to hold doubler. Remove DT8732 then cleco doubler with #30 clecos. Remove DT8879 open GHW to 0.500"

mm

14/03/02

02-03

BE14-0302

DC 14/02/03

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 3

Item ID: D206-642-641

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N900040100

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Revision ID:

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Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 1.00 *1*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

DL 14/02/03

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo 0.00

Quality Control

14-02-04 DAS 9 9-89

130

Chemical Conversion Coat per QSI005 4.1 0.00

130

HandFinish

Memo 0.00

Hand Finishing

14-02-04 DAS 9 9-89
1 16-14-2-3

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 4

Item ID: D206-642-641

Accept

N19000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC7-Inspect Chemical Conversion Coat	0.00				1	0	12	14/02/04
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Holes to finished size as per DWg D3288. Debur.								
	2-Locate, install and rivet doublers using DT8879 as per Dwg D3288. Micro-shave rivets as required.								
	3-Bond web in place as per Dwg D3288 & QSI 015.								
	A/RSikaflex-291 <u>127918</u>								
	Sikaflex expire date: <u>14/08/16</u>								
	Start: <u>14/02/04</u> Time: <u>11:30</u>								
	Finish: <u>14/02/14</u> Time: <u>11:00</u>								
	(Adhere for 12 hours)								

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 5

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NS1

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NS2

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Start Date: 2/03/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/11/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

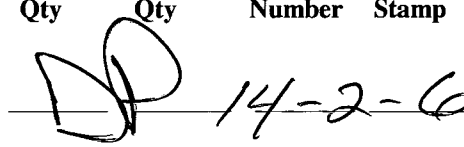
160

QC

Memo

0.00

Quality Control



170

0.00

170

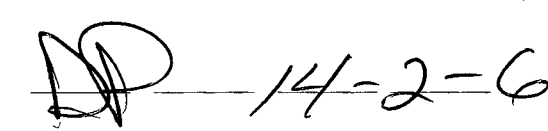
CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.



H-4.8"

145

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 6

Item ID: D206-642-641

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Skidtubes

Skidtubes

Memo

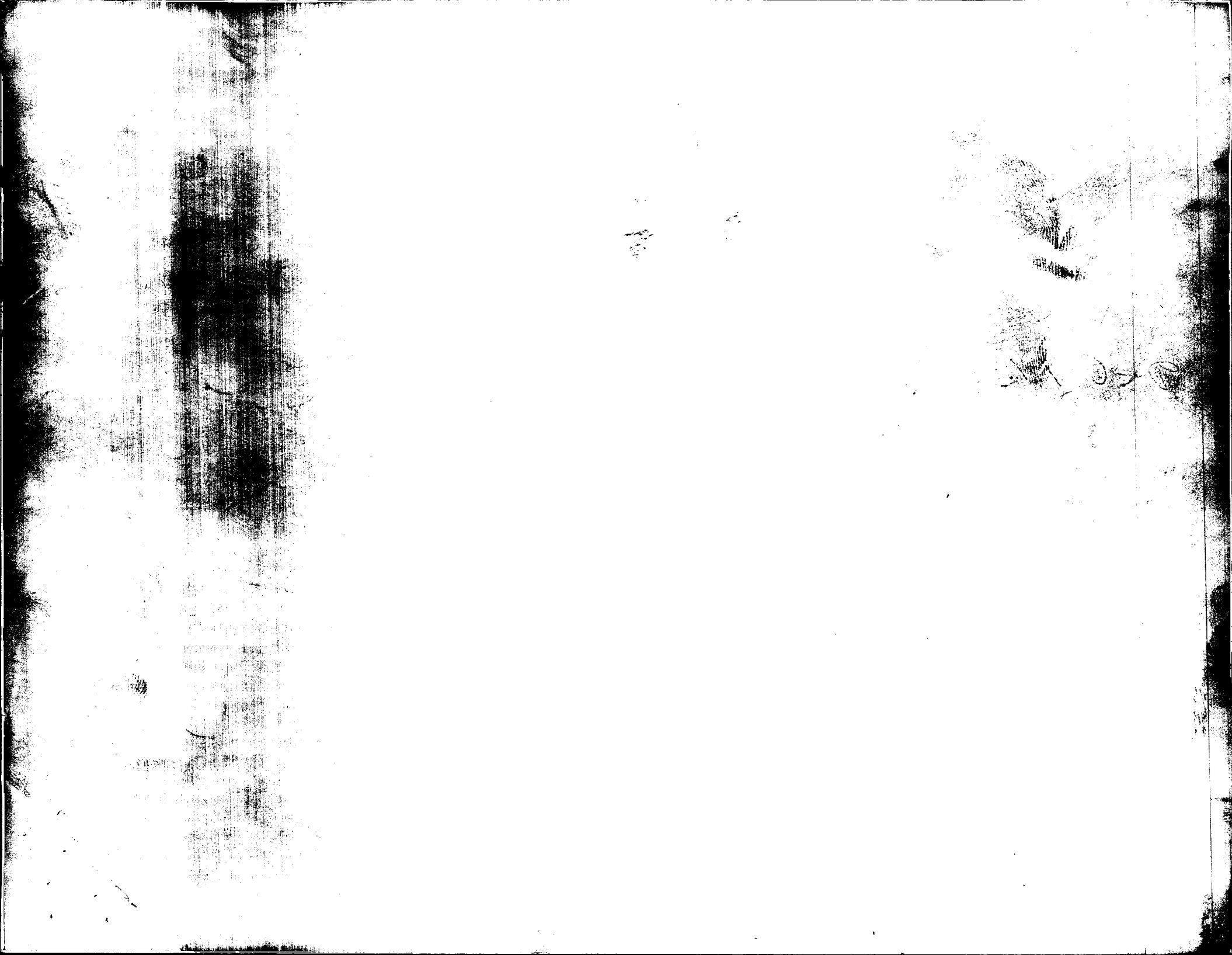
0.00

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Deburr and remove alodine as required for welding

DC 14/02/07



Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 7

Item ID: D206-642-641 Accept
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 Start Date: 2/03/14 Start Qty: 1.00 *1*
 Required Date: 2/11/14 Req'd Qty: 1.00 *1*
 Reference:

N900040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190									
Skidtubes	Memo	0.00							
Skidtubes	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod. A/RAluminum Rod <u>M1A2324</u> <u>BE 14/02/11</u>								
	2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required A/RSS Rod <u>NDNR</u> <u>BE 1402-13</u>								
	3-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube								
	4-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

14/02/12

① 14-02-11

DAS
9
9-89

BE 14/02/12

① 14-02-14

DAS
9
9-89

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 8

Item ID: D206-642-641

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N900040100

Setup Start

NS1

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NS2

Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/11/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC9- Inspect visual per QSI004- Fusion Welds

0.00

210

QC

Memo

0.00

Quality Control

① 14-02-14 ^{DAS}
9
9-89

220

Pressure Wash per QSI005 4.3

0.00

220

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 7/14 14-2-26

230

0.00

230

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2

PRIMER PRC DESOTO 515X349 BATCH: 126 543

2- PAINT WHITE AS PER DWG AND QSI 005 4.2

PAINT BATCH: 1128 330

1 CR 14-03-06

Tape/cover exposed Stanilys cross belt sprockets

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 9

Item ID: D206-642-641
 Revision ID:
 Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)
 Start Date: 2/03/14 Start Qty: 1.00
 Required Date: 2/11/14 Req'd Qty: 1.00
 Reference:

Accept

N19000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00 <i>SWF</i> <i>14/3/07</i>							
250 *250* HandFinish Hand Finishing	Memo 1-Install D3415-041 Nut Plate as per Dwg D3288 .Install with LPS PROCYON A/R LPS PROCYON Batch: <i>11122906</i> 2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes A/RSikaflex-291 <i>1412795</i> Sikaflex expire date: <i>14/07</i>	0.00 0.00							<i>1 ✓ of 14 14/03/07</i>
260 *260* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>1 ✓ 14-3-12.</i>

DAS 34 9-89

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 10

Item ID: D206-642-641

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearshoes/wearpads & Gaskets as per Dwg D3288.								
	2-Install Ring on Nut Plate as per detail F & Dwg D3288.								
	3-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-291 <u>11127918</u> Sikaflex expire date: <u>4/08</u>								
	4-Coat all exposed fastners with LPS Procyon,remove any exess on powder coat with MEK Degreasser. A/R LPS Procyon Batch: <u>11127900</u>								
280	QC5- Inspect part completeness to step on W/O	0.00							
280									
QC	Memo	0.00							
Quality Control									

DAS

27

9-89

14/3/12

Work Order ID 112621

February-03-14 7:42:17 AM

112621

Page 11

Item ID: D206-642-641 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)
 Start Date: 2/03/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/11/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290		0.00							
290									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-641								
	Location: _____								
	PPP Rev: _____								
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

PP2113823

DAS
06
9-89

MAR 17 2014

14-03-18

14-03-17

Picklist Print

February-03-14 7:42:15 AM

Page.1

Work Order ID: 112621
 Parent Item: D206-642-641
 Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 Required Date: 2/11/14
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:B05.11.15 Added washers for aft cap, wearshoes and ring EC
 IPP Rev:C 06-05-31 Revised steps JLM
 IPP Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM IPP Rev:E 07-12-06 ECN
 1080p DD verified by:ec
 IPP Rev:F 08-04-17 as per PAR 08-015 DD verified by: IPP REV:G 13.09.05 CHG004/
 ECN13-634 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 Skidtube, 206 Skidtube		Manufactured	No			110	Each	20.0000	1	1		mm 14/03/02	
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				LG		20							
				110799		20							
D2647 Cap		Manufactured	No			110	Each	11.0000	1	1		02/03 Dec 14/03/02	
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				LG001		11							
				102371		1							
				107588		10							
D3286-1 Doubler		Manufactured	No			110	Each	85.0000	2			Dec 14/02/03	
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				LG001		85							
				90503		2							
				91158		83							
CR3212-4-04 Cherry Rivet		Purchased	No			150	Each	548.0000	52			Dec 14/02/04	
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				ST327		98							
				123265		98							
				st552		450							
				m126534		10							
				n126691		440							

Picklist Print

February-03-14 7:42:16 AM

Page 2

Work Order ID: 112621
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Start Date: 2/03/14 Required Date: 2/11/14
 Start Qty: 1.00 Required Qty: 1.00

D3289-041 Manufactured No 150 Each 1.0000
 Float Web (206A/B)

Location	Loc Qty	Loc Code
LG002	1	
105270	1	

1 De 14/02/04

D2649 Manufactured No 190 Each 327.0000
 Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG001	327	
107906	145	
108633	176	
90497	6	

9 BE1402-11

D3275-1 Manufactured No 190 Each 186.0000
 Crossbolt Spacer

Location	Loc Qty	Loc Code
LG001	186	
104849	21	
107892	39	
109096	126	

6 BE1402-11

D3286-3 Manufactured No 190 Each 123.0000
 Spacer

Location	Loc Qty	Loc Code
LG001	123	
100097	61	
91160	62	

2 BE1402-13

D3415-041 Manufactured No 250 Each 31.0000
 Nut Plate

Location	Loc Qty	Loc Code
ST042	31	
106195	31	

1 14/03/12

February-03-14 7:42:16 AM

Shop Packet Print

Page 2

Picklist Print

February-03-14 7:42:16 AM

Page 3

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Start Date: 2/03/14 Required Date: 2/11/14
 Start Qty: 1.00 Required Qty: 1.00

CCR264SS3-3 Purchased No 250 Each 296.0000 2 2 14/03/12
 Cherry Rivet

Location	Loc Qty	Loc Code
ST327	296	
m126282	132	
m126333	164	

CR3212-4-03 Purchased No 250 Each 1,183.0000 2 2 14/03/12
 Cherry Rivet

Location	Loc Qty	Loc Code
ST327	1083	
114889	1	
119017	700	
m123265	382	
st552	100	
m114859	100	

ALS7-1032-130 Purchased No 250 Each 856.0000 64 64 14/03/12
 Rivnut

Location	Loc Qty	Loc Code
FG	100	
121444	100	
ST279	756	
119530	73	
122763	22	
124226	50	
m126109	611	

D3535-15 Manufactured No 270 Each 15.0000 1 1 14/03/12
 Stainless Steel Wearplate Fwd

Location	Loc Qty	Loc Code
FP002	15	
106776	2	
110201	13	

February-03-14 7:42:16 AM

Shop Packet Print

Page 3

Picklist Print

February-03-14 7:42:16 AM

Page 4

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Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

D3535-21 Manufactured No 270 Each 5.0000
Stainless Steel Wearplate Center Fwd

1 1 1 14/03/12

Location Loc Qty Loc Code

FP001 5 B110678
102342 5

xi

D3535-35 Manufactured No 270 Each 5.0000
Stainless Steel Wearplate Aft

1 1 1 14/03/12

Location Loc Qty Loc Code

FG 2 B112440
94685 2
FP002 3
108053 3

xi

D3535-41 Manufactured No 270 Each 7.0000
Stainless Steel Wearplate Center Aft

1 1 1 14/03/12

Location Loc Qty Loc Code

FP002 7
42256 7

xi

D3536-15 Manufactured No 270 Each 17.0000
Gasket Fwd

1 1 1 14/03/12

Location Loc Qty Loc Code

FG 4 B113051
85604 2
93893 2
FP001 13
107965 1
110698 12

xi

D3536-21 Manufactured No 270 Each 7.0000
Gasket Center

1 1 1 14/03/12

Location Loc Qty Loc Code

FP001 7
104203 7

xi

February-03-14 7:42:16 AM

Shop Packet Print

Page 4

Picklist Print

February-03-14 7:42:16 AM

Page 5

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Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

D3536-35 Manufactured No 270 Each 14.0000
 Gasket Aft

1 1 1/03/12

Location	Loc Qty	Loc Code
FG	6	B112374
89650	2	
93911	4	
FP001	8	
109783	8	

x1

D3536-41 Manufactured No 270 Each 9.0000
 Gasket Center Aft

1 1 1/03/12

Location	Loc Qty	Loc Code
FP001	9	
51646	9	

x1

D3537-1 Manufactured No 270 Each 18.0000
 Wearpad

7 7 1/03/12

Location	Loc Qty	Loc Code
FG	18	B113288
79833	8	
88562	10	

x7

D3537-3 Manufactured No 270 Each 21.0000
 Wearpad

1 1 1/03/12

Location	Loc Qty	Loc Code
FG	8	B111825
86237	8	
FP002	13	
103014	13	

x1

Picklist Print

February-03-14 7:42:16 AM

Page 6

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Parent Item: D206-642-641
Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Bolt	Purchased	No	270	Each	2,802.0000	66	66	11/03/12
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FG	20				
			122814	20				
			ST513	2782				
			125388	1835				
			M127410	447				
			M127832	500				
NAS1515H3L Washer	Purchased	No	270	Each	440.0000	2	2	11/03/12
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FG	40				
			102472	40				
			ST297	400				
			m127831	400				
NAS1149C0332R WASHER	Purchased	No	270	Each	10,120.000	78	78	11/03/12
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA	1185				
			125654	1185				
			st510	8935				
			m126319	1059				
			m127306	2500				
			m127410	3000				
			m127831	2376				
D3683-1 Insert	Manufactured	No	270	Each	4,066.0000	12	12	11/03/12
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001	4066				
			36319	4066				

February-03-14 7:42:16 AM

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Page 6

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February-03-14 7:42:17 AM

Page 7

Work Order ID: 112621

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

D3413-1 O-Ring Manufactured No 270 Each 25.0000 1 11/03/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST464	25	
106048	7	
107984	16	X 1
98167	2	

AN4C5A Bolt Purchased No 270 Each 114.0000 1 11/03/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST355	114	
122599	44	X 1
123265	20	
M127410	50	

NAS1149C0463R Washer Purchased No 270 Each 476.0000 1 11/03/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	21	
119097	21	X 1
ST292	455	
123248	1	
123355	154	
m127306	300	

D2646 Aft Cap Manufactured No 270 Each 23.0000 1 11/03/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	13 110816
85848	2	X 1
90495	2	
FP001	19	
103306	18	
107857	1	

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Page 8

Work Order ID: 112621

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

MS27039C1-05

Purchased

No

270

Each

202.0000

12

12

SCREW

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

Location

Loc Qty

Loc Code

ST309

202

107242

202

x12

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Page 8

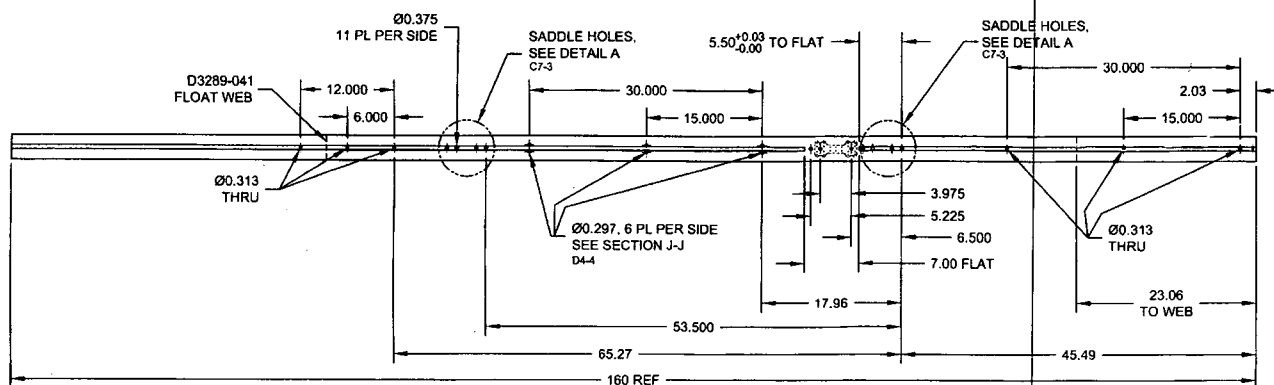
Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

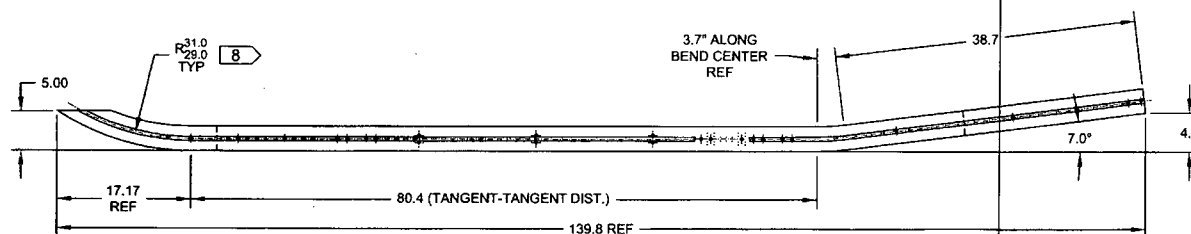
- MATERIAL: N/A
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: 20.8 LBS
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN.
- DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/291.
- WELDING: PER DART QSI 004.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY. CLEAN OFF EXCESS GREASE WITH WASH 'N WIPE DEGREASER

RELEASED
Q 13/4/4
GEN 15-567

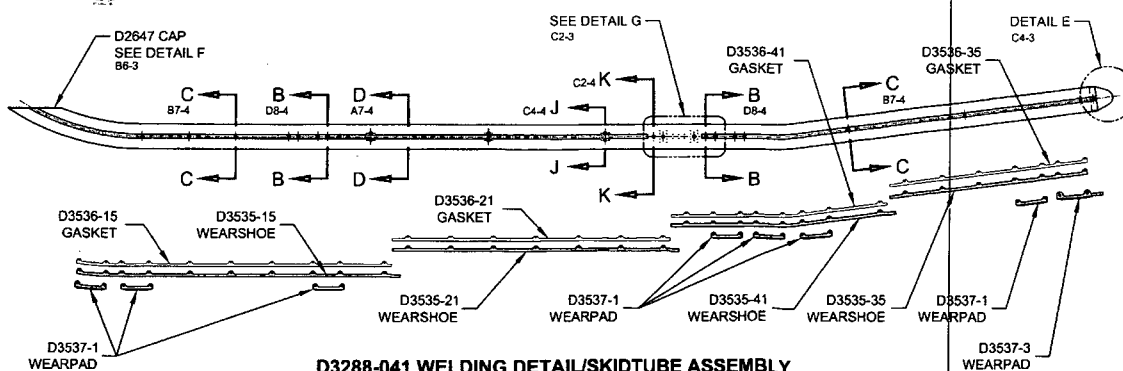
H	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-258	DW	13.05.21
G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.08.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D3288	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SKIDTUBE ASSEMBLY	NTS
DATE	13.05.21	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3288-041 DRILLING/WEB ASSEMBLY DETAIL



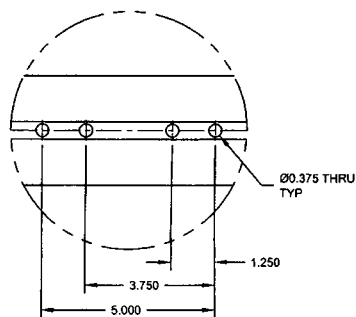
D3288-041 BENDING DETAIL



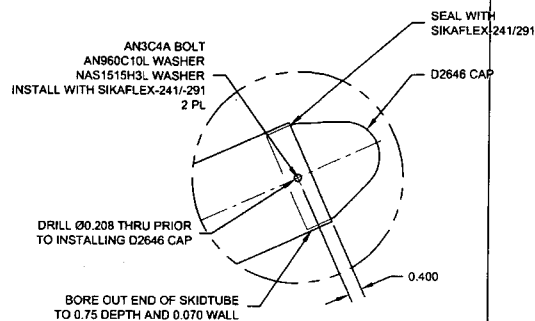
D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

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9/13/14

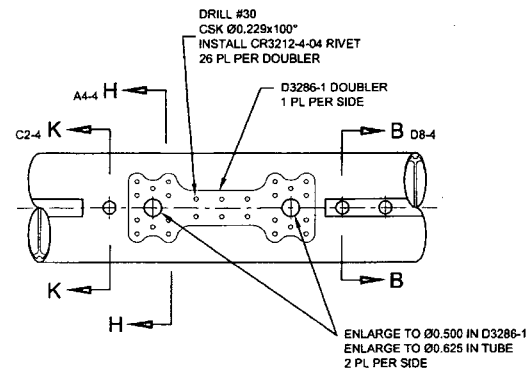
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MFG. APPR.	DD	D3288	SHEET 2 OF 4
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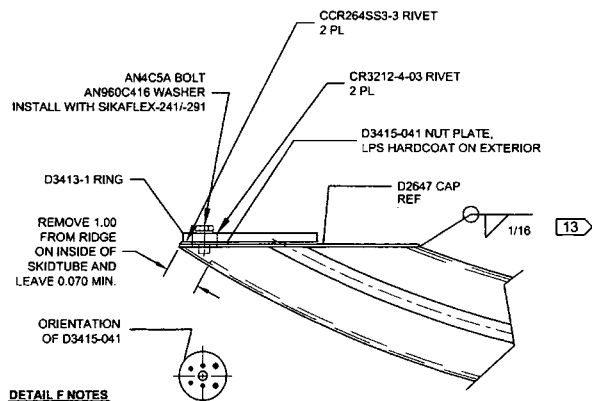
DETAIL A: DRILL DETAIL
SADDLE HOLES, SCALE 5X
D6-2, D4-2



DETAIL E
SCALE 5X
B3-2



DETAIL G
SCALE 5X
B5-2



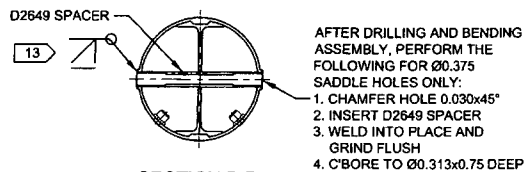
DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL
SCALE 5X
B7-2

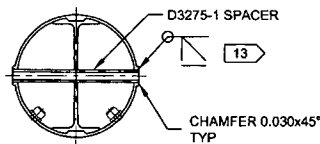
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9/15/94

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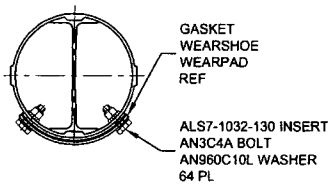
SECTION B-B

FOR Ø0.375 SADDLE HOLES ONLY
8 PL, SCALE 5X
B7-2, B5-2, D1-3



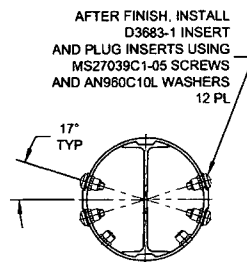
SECTION C-C

FOR Ø0.313 HOLES ONLY
6 PL, SCALE 5X



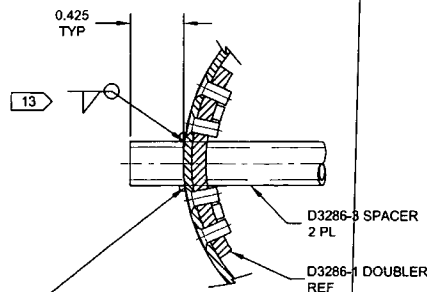
SECTION D-D

FOR WEARSHOES INSTALL ONLY
32 PL, SCALE 5X
B6-2



SECTION J-J

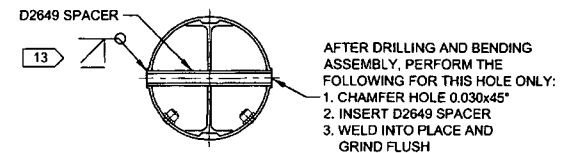
SCALE 5X
D5-2, B6-2



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION H-H


NOT TO SCALE
D3-3



SECTION K-K

1 PL, SCALE 5X
B5-2

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13/19/14

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MFG. APPR.	DD	D3288	SHEET 4 OF 4
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No. 336

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott
Job #: 103007
Part #: D206-642-151
Description: 206 skid tube
Welding Process: TIG ☒ MIG ☐
Base Material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Penetration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Fusion:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>

Qualifier: DAS
9
9-88

Date of Test Coupon: 13-11-14

Welder: Barclay Elliott

Date of Test Coupon: 13-11-14

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.